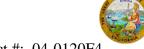
### DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 99.28

## WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-014454 Address: 333 Burma Road **Date Inspected:** 22-May-2010

City: Oakland, CA 94607

**OSM Arrival Time:** 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island **Location:** Shanghai, China

**CWI Name: CWI Present:** Yes No Mr. Zhou Cheng **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No **Delayed / Cancelled:** Yes No N/A

34-0006 **Bridge No: Component: OBG Segment 10AW** 

## **Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) - Document: 005795

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 10BE. The weld designations reviewed are as follows:

- 1. SEG062A-008
- 2. SSD19-PP90-132
- 3. Temporary attachment areas on PP 91 West Side

Magnetic Particle Testing (MT) - Document No's: 005771

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Segment 10AW. The weld designations reviewed are as follows:

- 1. SEG059C-001, 002, 009~012, 016, 031, 032, 041, 042
- 2. SSD21-PP85.5-079~084, 087~092

# WELDING INSPECTION REPORT

(Continued Page 2 of 2)

3. SSD10-PP086-039~044, 047~052, 097~102, 105~111

Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 062788 perform Flux Cored Arc Welding (FCAW) welding on Suspender Bracket, weld joint identified as SB012-058-049. ZPMC QC is identified as Mr. Zhou Cheng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062738 perform FCAW Welding on Suspender Bracket, weld joint identified as SB013-062-019 and 020. ZPMC QC is identified as Mr. Zhou Cheng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA Inspector observed ZPMC personnel performing Ultrasonic Testing (UT) on Suspender Brackets SB68E, SB66E, SB64E and SB62E.

This QA Inspector observed ZPMC personnel performing fit-up welding on BK004A-008 at Bay 19.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

#### **Summary of Conversations:**

Only general conversation was held between QA and QC concerning this project.

## **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact, who represents the Office of Structural Materials for your project.

| <b>Inspected By:</b> | Kumar, Vibin       | Quality Assurance Inspector |
|----------------------|--------------------|-----------------------------|
| Reviewed By:         | McClendon, Timothy | QA Reviewer                 |